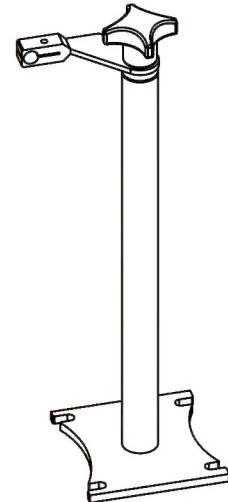
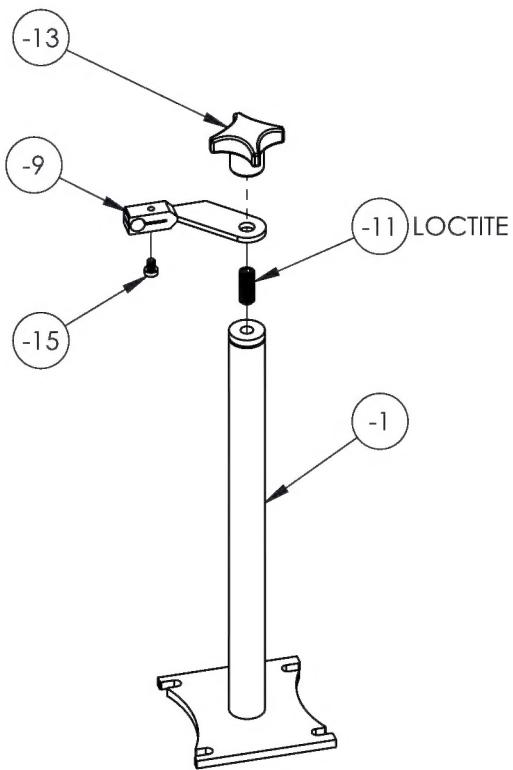


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	8/1/2016	RJC	JAG

**SEE ATTACHED DEVIATION**



NOTE:  
REF. EUROCOPTER T/N 105-31702W24.

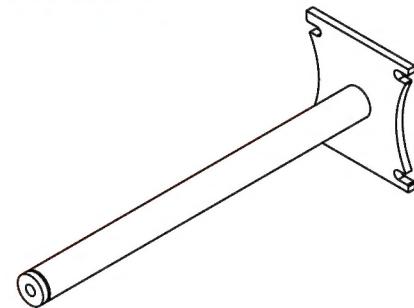
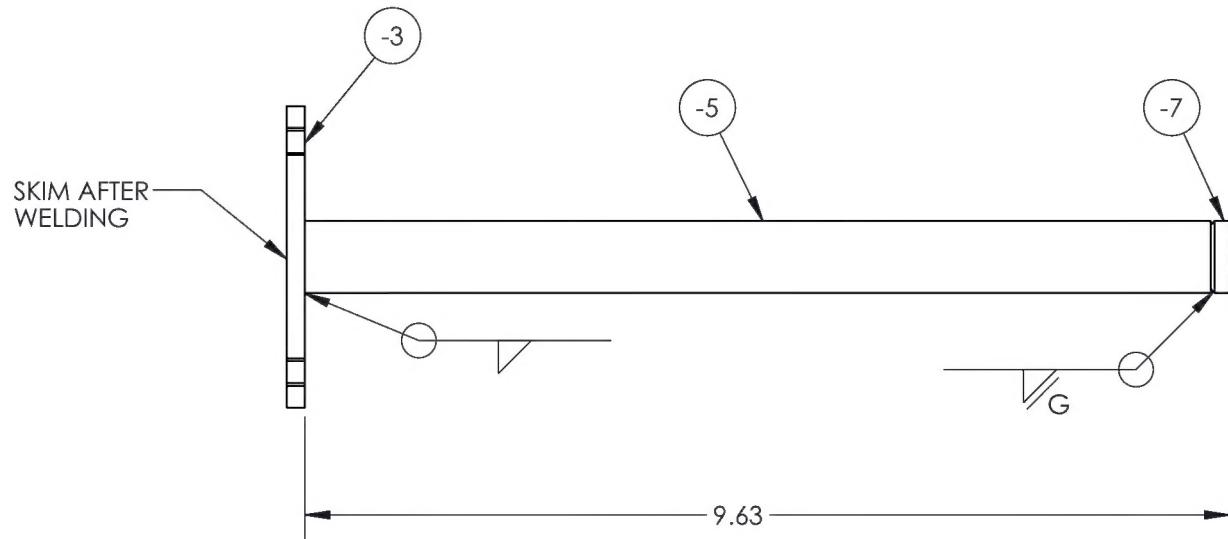
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
X			-1	1	WELDMENT			2
1			-3		BASE PLATE	A36/1018/1020 HR		3
1			-5		TUBE	DOM		4
1			-7		CAP	A36/1018/1020 HR		5
			-9	1	ARM	A36/1018/1020 HR		6
	B/O	-11	1		SET SCREW	STEEL	M8 X 1.25 X 20mm (MCMASTER-CARR #93245A145)	1
	B/O	-13	1		FOUR ARM KNOB	PHENOLIC	M8 X 1.25, 40mm (MCMASTER-CARR #6390K23)	1
	B/O	-15	1		SOCKET HARD CAP SCREW	STEEL	M4 X .7 X 6mm (MCMASTER-CARR #90327A111)	1
ASSY -1								

TITLE		REV
MEASURING DEVICE		1
RBE105-31702W24		
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8	
FINISH	.XX ± .01 ANGLES ± 5°	
SPEC	X ± .1 SURFACES = 125	
DRAWN BY:	CLOUGH	
CHECKED:	DUFERFELDT	
OPPS APPR:	ANDERSON	
QA APPR:	LINDSAY	
APPROVED:	GILBERT	
SCALE	1:4	DATE 7/15/2016
		SHEET 1 OF 6

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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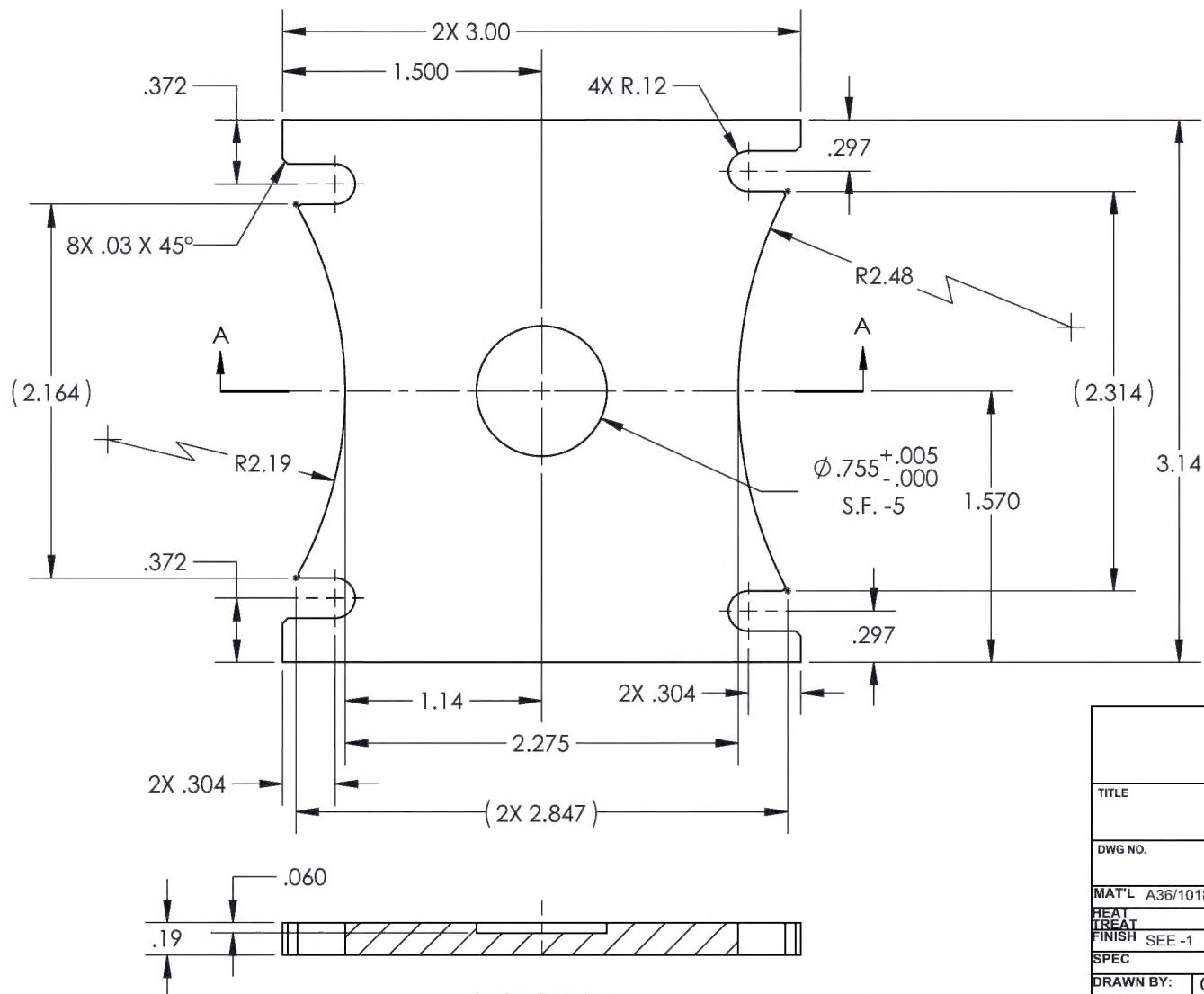
**SEE ATTACHED DEVIATION**



(-1)  
WELDMENT

DART AEROSPACE	
TITLE	
MEASURING DEVICE	
DWG NO. RBE105-31702W24-1 REV 1	
MAT'L	
HEAT	
TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY: CLOUGH	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 7/15/2016
USED ON MODEL	
EC145	
SCALE 1:2 DATE 7/15/2016 SHEET 2 OF 6	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	

**SEE ATTACHED DEVIATION**



## SECTION A-A

-3

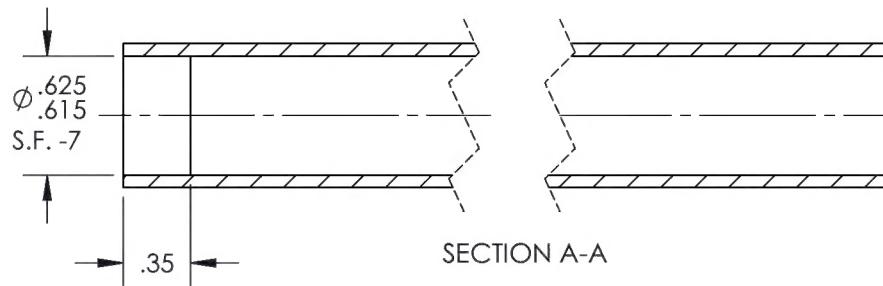
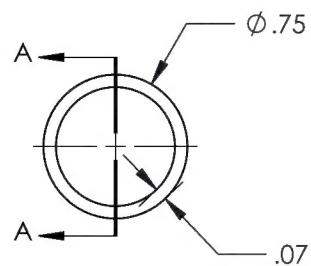
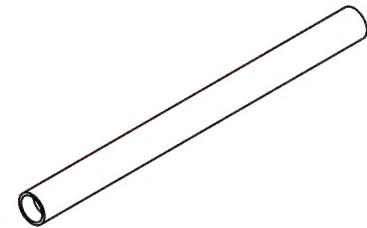
## BASE PLATE

	
TITLE	
MEASURING DEVICE	
DWG NO.	RBE105-31702W24-3
REV 1	
MAT'L A36/1018/1020 HR	
FEAT TREAT	
FINISH SEE -1	
SPEC	
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:1
DATE	7/15/2016
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° X ± .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
EC145	
SHEET 3 OF 6	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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**SEE ATTACHED DEVIATION**



(-5)

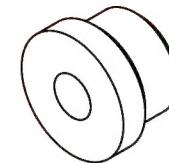
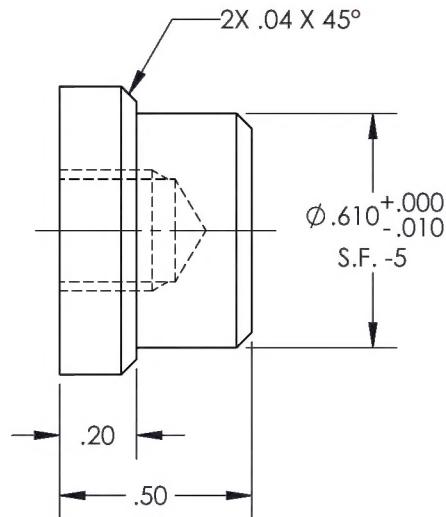
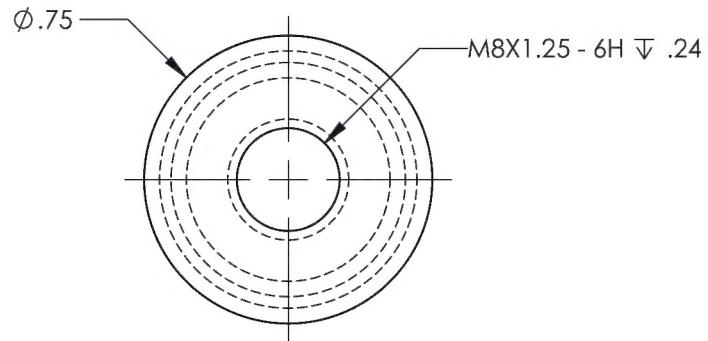
TUBE

DART AEROSPACE	
TITLE	
MEASURING DEVICE	
DWG NO. RBE105-31702W24-5	
REV 1	
MATERIAL DOM	
HEAT	
TREAT	
FINISH SEE -1	
SPEC	
DRAWN BY: CLOUGH	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 7/15/2016
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145	
SHEET 4 OF 6	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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**SEE ATTACHED DEVIATION**



(-7)

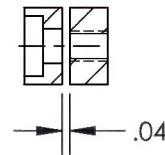
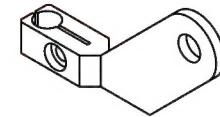
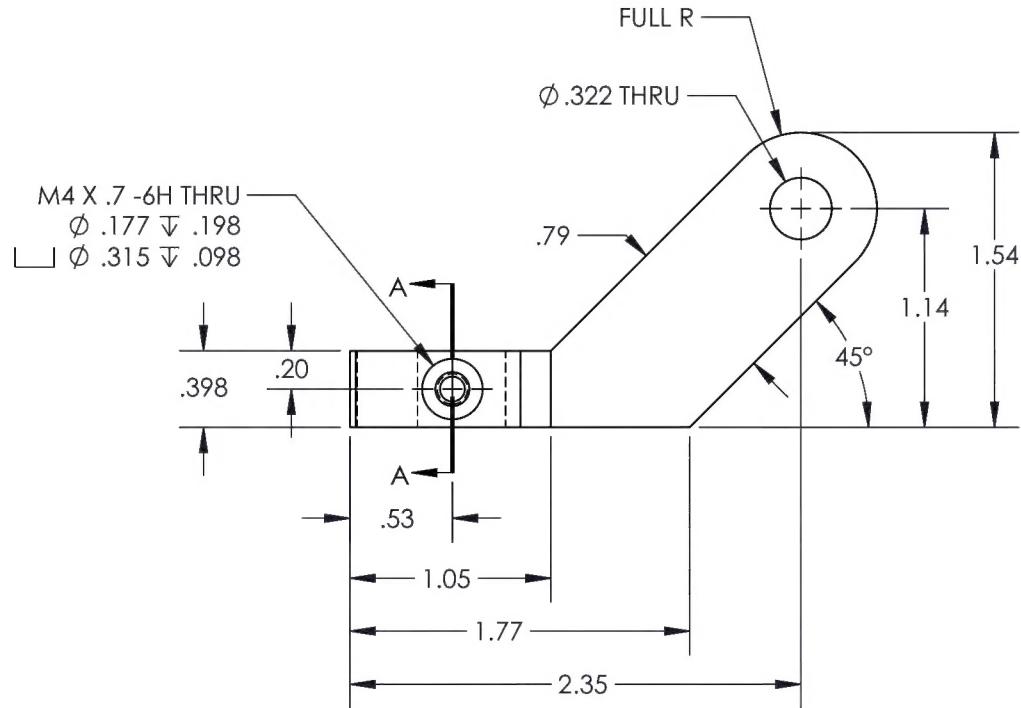
CAP

DART AEROSPACE	
TITLE	
MEASURING DEVICE	
DWG NO. RBE105-31702W24-7	
REV 1	
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 2:1	DATE 7/15/2016
SHEET 5 OF 6	

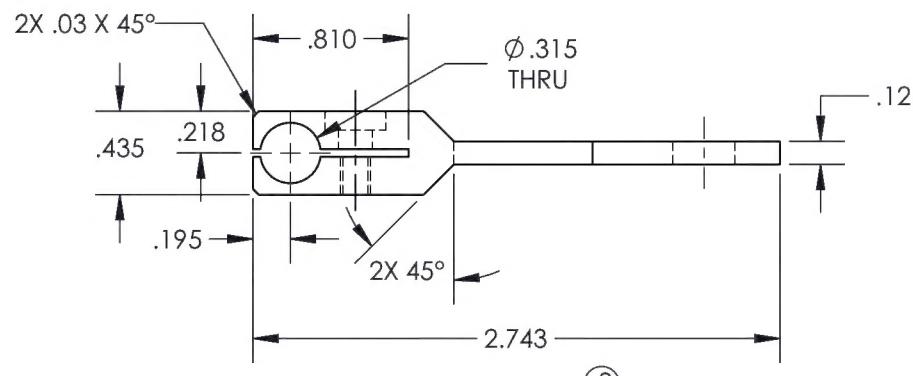
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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
				APPROVED

## SEE ATTACHED DEVIATION



SECTION A-A



(-9)  
ARM

DART AEROSPACE	
TITLE	
MEASURING DEVICE	
DWG NO. RBE105-31702W24-9	
REV 1	
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
HEAT .XXX +/- .005 FRACTIONS +/- 1/8	
TREAT .XX +/- .01 ANGLES +/- 5°	
FINISH ZINC PLATE .X +/- .1 SURFACES = 125 ✓	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY: CLOUGH	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	EC145
SCALE 1:1	DATE 7/15/2016
SHEET 6 OF 6	

Entered: Date:



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

### Route update only

Job: _____	DISPOSITION			DEPARTMENT/PROCESS				
Part No. RBE105-31702W24P Rev. 1	Rework	Scrap	Use-as-is	Skid-tube	Cross tube	Eng. (Non-AW)	Engineering	
				Machining	Small Fab	Prod. Eng. Coor.	Water Jet	
				Large Fab	Finishing	Rec/Store/Packaging	Supplier Quality	
Date : _____	Sequence #:	QTY Affected :				MRB (QSI042)		
						December 7, 2018		
Description		Work Order	Deviation	Disposition				
RBE105-31702W24-5 and -7 must be manufactured as one piece from 303/304 Stainless Steel rod.		This deviation is acceptable.				Completed By		
RBE105-31702W24-3 must be manufactured from 303/304 Stainless Steel plate.		No change to fit form or function of the tool.				Lead hand / Supervisor		
Zinc Plate is no longer required						QC / QA Coordinator		
Root Cause		FAULT CATEGORY						
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing
Product Improvement	X	Marks/Chatter		Drill Holes		Out of Sequence		Misread
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up		
Human Factors		Other/Details:						